

SPLIT

Date: Wednesday, 11/03/2009 12:58:50 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 46433 -2	
Estimate Number : 10531	
P.O. Number :	Part Number : D2572
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 45922	Material :
Written By :	Due Date : 04/04/2009 Qty: 12 Um: Each
Checked & Approved By : <u>J.D. 09-03-11</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

(7)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: B34874

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 46433 Double check by: mmf

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

J.L mmf 09/04/09

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

J.L mmf 09/04/07

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Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 46433

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / MF 09/04/07

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MF 09/04/13 (7)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

JL 09-04-14 (X2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939.

START TIME:

3:45

OVEN TEMPERATURE:

320°

FINISH TIME:

4:15

MF 09-04-14 (7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-04-15 (X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5433

A 09-04-15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



MF 09-04-15

DART AEROSPACE LTD		Work Order: H10433
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440	.440		
B	1.745	1.755		1.750	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.498	3.500		
D	1.745	1.755		1.750	1.747	1.747	1.748		
E	7.990	8.010		8.000	8.002	8.001	8.003		
F	0.490	0.510		.497	.498	.500	.499		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.375	.377	.376		
I	0.490	0.510		.502	.508	.508	.506		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.569	.576	.573	.575		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.125	.124	.124	.129		
Q	0.115	0.135		.135	.135	.135	.134		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.958	2.959		
V	0.230	0.250		.239	.240	.240	.239		
W	0.115	0.135		.129	.130	.130	.130		
X	0.307	0.312		.310	.312	.313	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.363	.364	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.625	.625	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.242	.250	.250		
AE	1.375	1.395		1.390	1.391	1.392	1.393		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.245	.245	.242		
AI	2.000	2.020		2.005	2.006	2.008	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	09/04/05

Audited by:	[Signature]
Date:	09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order: 46433
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 5	2 6	3 7	4 8		
A	0.438	0.443		.440	.441	.441	.440		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.496	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.000	8.001		
F	0.490	0.510		.500	.503	.502	.502		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.378	.376	.376		
I	0.490	0.510		.507	.506	.510	.510		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		.575	.573	.578	.578		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.497	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	3.869	3.879		3.870	3.871	3.874	3.874		
P	0.115	0.135		.125	.125	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.250	.250		
S	0.115	0.135		.130	.129	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.958	2.960	2.960		
V	0.230	0.250		.238	.238	.239	.240		
W	0.115	0.135		.129	.125	.123	.125		
X	0.307	0.312		.310	.312	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.244	.243	.242		
AE	1.375	1.395		1.391	1.391	1.391	1.391		
AF	0.115	0.135		.132	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.243	.246	.244	.245		
AI	2.000	2.020		2.008	2.005	2.005	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J.L.
Date:	09/04/13

Audited by:	ml
Date:	09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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DART AEROSPACE LTD	Work Order: 46433
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

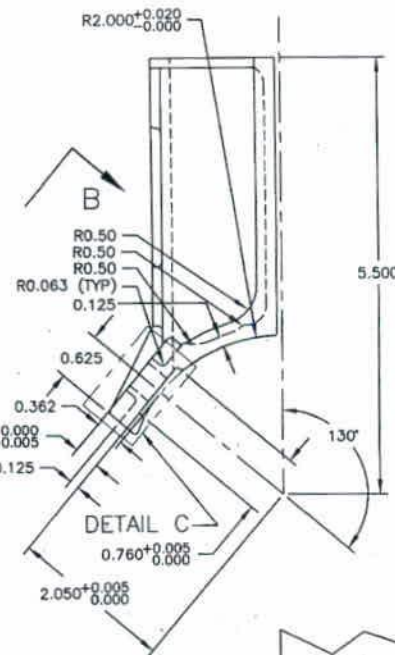
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	311	412		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.746	1.746	1.748	1.748		
C	3.495	3.505		3.499	3.499	3.499	3.500		
D	1.745	1.755		1.748	1.746	1.747	1.748		
E	7.990	8.010		8.003	8.004	8.004	8.001		
F	0.490	0.510		.491	.506	.500	.498		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.499	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.561	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.130	.131	.127	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.954	2.958		
V	0.230	0.250		.242	.242	.241	.240		
W	0.115	0.135		.135	.134	.135	.135		
X	0.307	0.312		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.364	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.244	.245	.250		
AE	1.375	1.395		1.390	1.391	1.390	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.246	.246	.247		
AI	2.000	2.020		2.004	2.005	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J.L. / mmt
Date:	09/04/11

Audited by:	Jmk
Date:	09/04/13

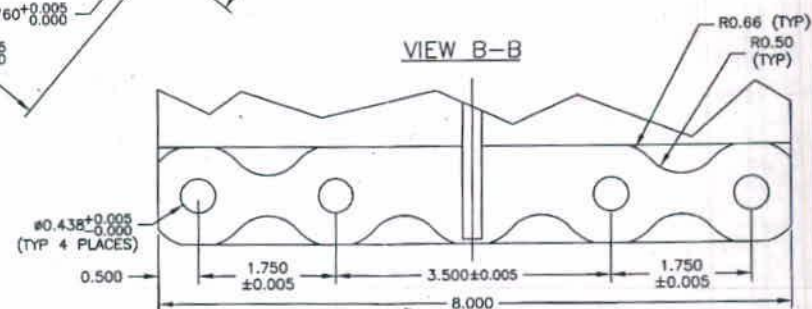
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B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



05.12.06 

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E



SECTION A-A

VIEW B-B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4643

DETAIL C
SCALE 2:1

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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE
		REV. SHEET 1 OF 2
		SCALE